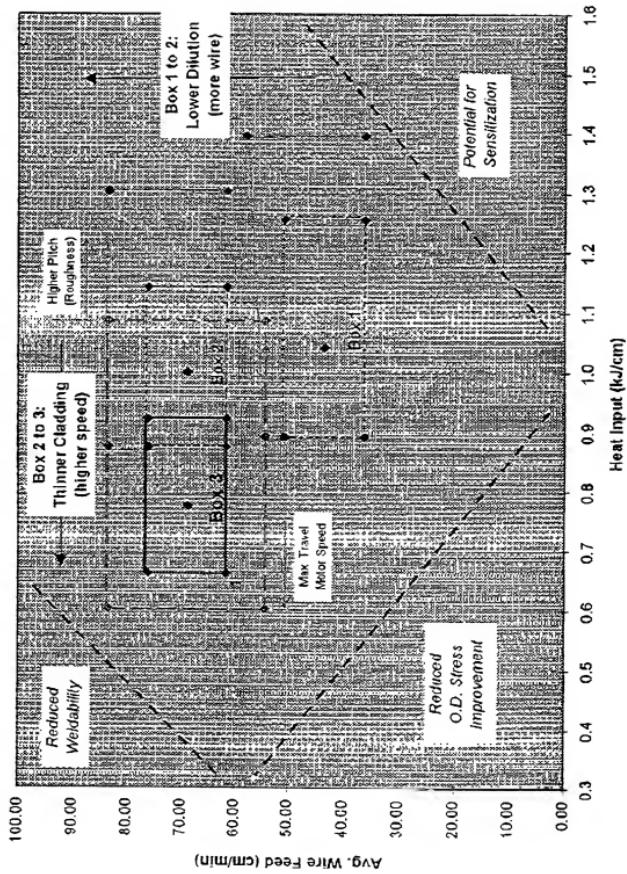


FIG. 1

Heat Boxes 1, 2, 3 (with Reference Points)



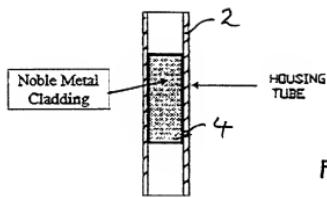


FIG. 2A

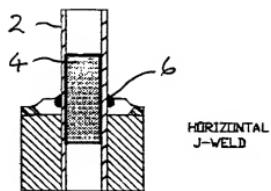


FIG. 2B

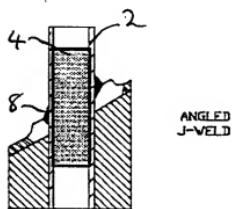
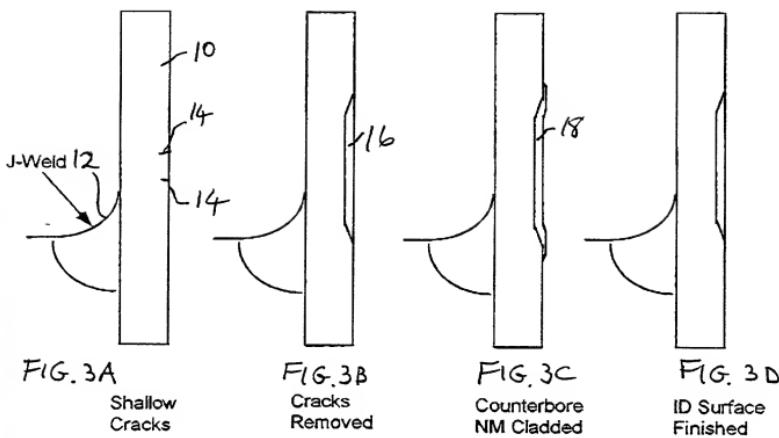
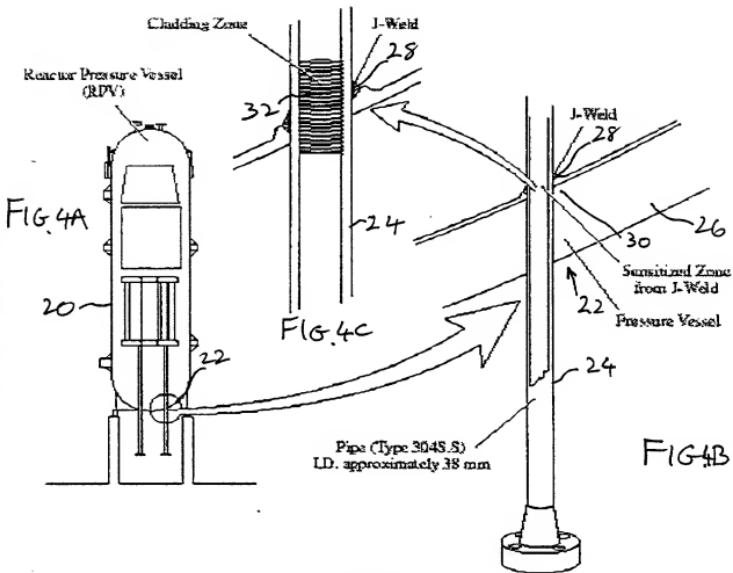


FIG. 2C

202504057.042202





ICMH Mitigation

FIG. 4

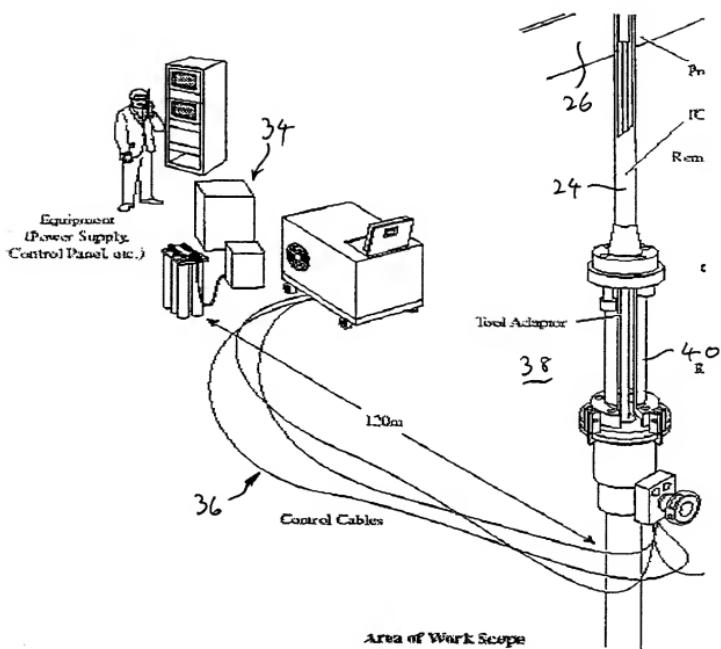
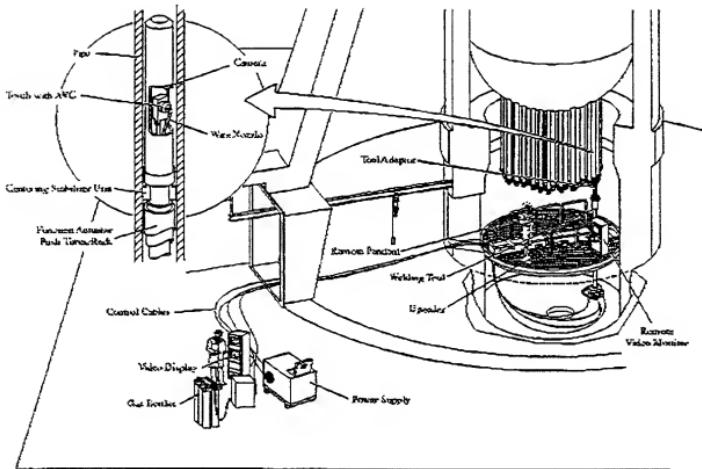


FIG. 5



Welding System with Weld Head Installed

FIG. 6

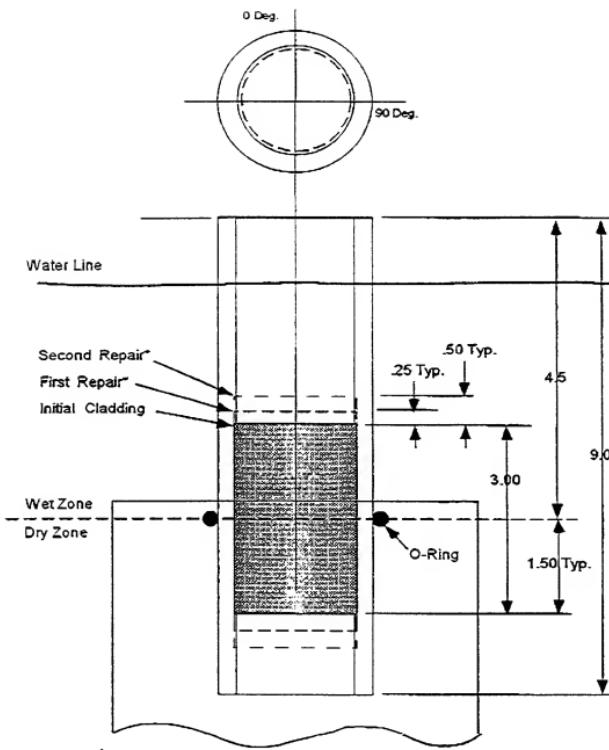
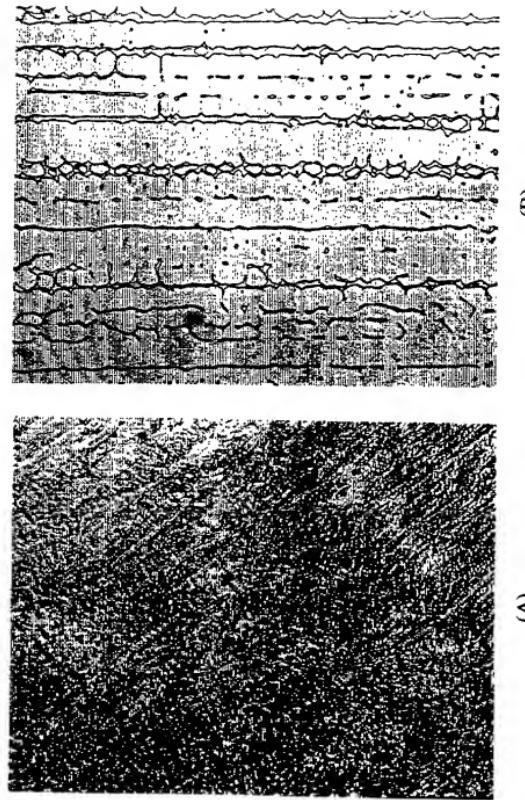


Fig. 7

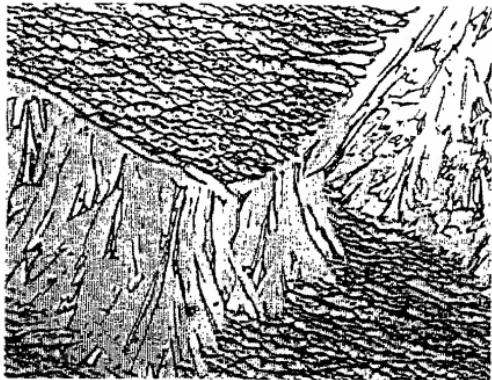


Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 316L + Pd Filler,
800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

FIG. 8



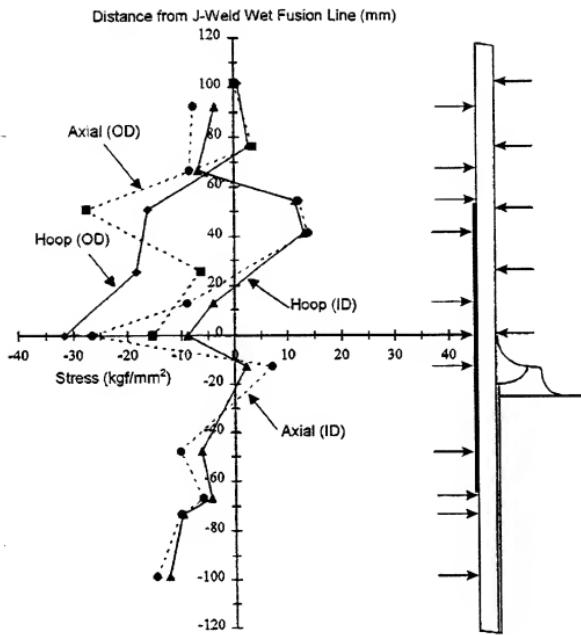
(A)



(B)

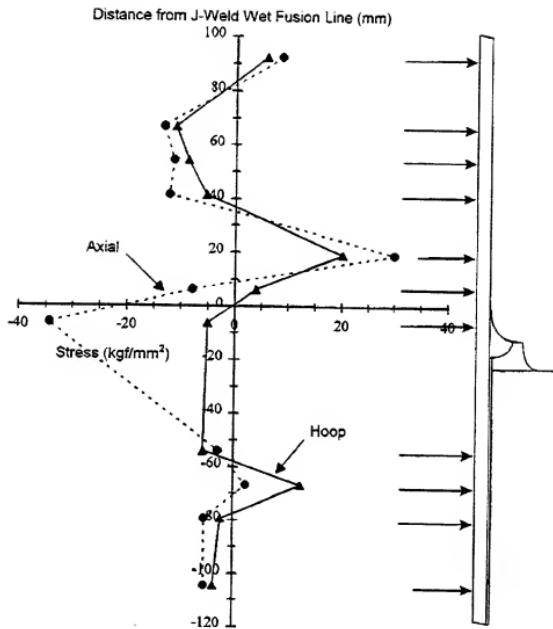
Micrographs Comparing Ferrite Size and Distribution for NM Cladding with Type 308L +1PT Filler, 800 X Magnification. (A) Mechanized ICMH Cladding, (B) Manual Cladding

Fig. 9



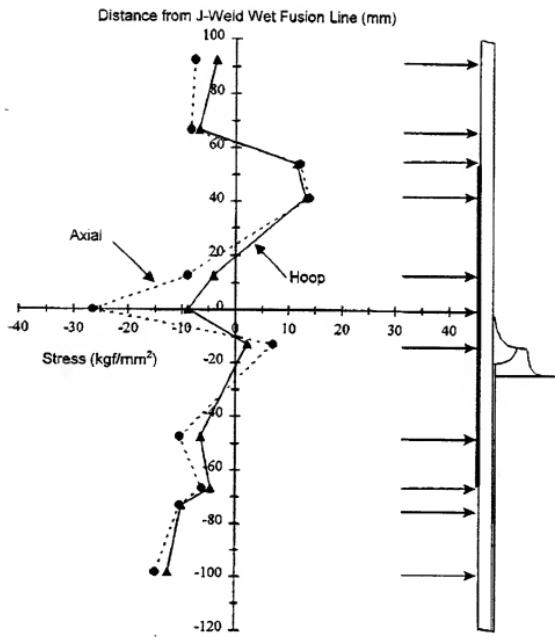
ID/OD Residual Stress (Clad)

FIG. 10A



ID Residual Stress (no clad)

FIG. 10 b



ID Residual Stress (clad)

FIG. 10C